

Work Order ID 110597

Friday, January 03, 2014 10:07:54 AM

110597

Page 1

Item ID: PB67-43001-171

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Mounting Plate

Start Date: 1/3/2014 Start Qty: 96.00

96

61

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 96.00

96

Customer:

Reference:

Approvals: Process Plan: mf Date: 14-01-03

Tooling:

Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N):

Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	C								

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- cut as per dwg PB67-43001-171

2- deburr

FR 14/02/02

62

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes as per dwg PB67-43001-171

FR 14/02/02

62

120

0.00

120

QC

Memo

0.00

Quality Control

QC 14/02/02

QC 1- Inspect part completeness to step on W/O

FR 14/02/02

62

125 QCB

FR 14.02.02

FR 14.02.02

61

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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110597

Page 3

Item ID: PB67-43001-171

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Mounting Plate

Stop ***NS2***

Start Date: 1/3/2014 Start Qty: 96.00

96

Cust Item ID:

Required Date: 1/31/2014 Req'd Qty: 96.00

96

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ 14-02-05

④ 14-02-04

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Picklist Print

Friday, January 03, 2014 10:07:54 AM

Page 1

Work Order ID: 110597

Parent Item: PB67-43001-171

Parent Item Name: Mounting Plate

Start Date: 1/3/2014

Required Date: 1/31/2014

Start Qty: 96.00

Required Qty: 96.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6A1.000W.125 6061T6 ANGLE 1.00 x 1.00 x .125W		Purchased	No			100	f	6.0000	0.0833	9			

Location

Loc Qty

Loc Code

MAT006

6

125006

6

MS20426AD3-4

Purchased

No

130

Each

11,543.000

2

192

RIVET

Location

Loc Qty

Loc Code

ST334

4000

m127432

4000

ST509

7543

125578

7543

MS21075L3

MS21075L3N

Purchased

No

130

Each

137.0000

1

96

Nut Plate

Location

Loc Qty

Loc Code

GA

137

125646

137

15

M127993

46x

58 14-02-03 DAS 36 9-89
14/02/03

122 14/02/03 DAS 36 9-89

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FAULT CATEGORY

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8 7 6 5 4 3 2 1

D

C

B

A

D

C

B

A

0.13
REF

RADII
OPTIONAL

1.00
TYP, REF

$\triangle C$ $\phi 0.098$ THRU
 $\phi 0.167 \times 100^\circ$ CSK
2PL

$\triangle C$

0.500

$\triangle C$

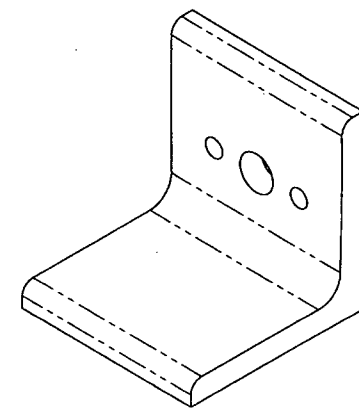
0.250

$\phi 0.194$
THRU

0.500

0.500

1.00



B67-43001-171 MOUNTING PLATE

110597
mf
14-0-03
RELEASED
2009-09-24
md

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6510/T6510/T6511) ALUMINUM ANGLE
PER AMS-QQ-A-200/8
REF. DART SPEC. M6061T6A1.00XW125
- 1) MATEROR: D6207-001
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 27 OF PREMIER AVIATION DRAWING No. B67-43001; ADDED CSKED Ø0.098 THRU HOLES. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED	ASS	DRAWING NO.	REV. C	
MFG. APPR.		B67-43001-171	SHEET 1 OF 1	
APPROVED	md	TITLE	SCALE	
DE APPR.	N/A	MOUNTING PLATE		NTS
DATE	09.02.19		COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

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